Work Order Wednesday, Augus												Page 1
Item ID: D Revision ID:	03574-6			Accept				s	etup S	tart		
Item Name: C	abin Floor Pro	otector							S	top		
Start Date: 8/ Required Date: 8/ Reference:		Start Qty: 2.00 Req'd Qty: 2.00	***************************************		Cust Item I Customer:	D:						
Approvals:	Process Plan	: UMF	Date: [0-8-18	Tooling:	D:	ate:		F				
•	QC:		Date:	SPC (Y/N):	D	ate:			S	Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty		eject imber	Insp. Stamp
Draw Nbr	Revis	sion Nbr										
D3574	Rev I	3										
Waterjet FLOW CNC Waterjet			per Dwg D3574 ©Dwg Renecessary	0.00 0.00 v:□Prog Rev:_	<u>R</u> ====================================			-8	10-8	-18_	(	<u> </u>
110 QC Quality Control		QC2- Inspect parts off  Memo	f machine FAI/FAIB	0.00			_	FF.	0-8-	18_		
120		QC8-Inspect parts - s	econd check	0.00	<b>&gt;</b>							
				$\leq 10$	dacha			$\bigcirc$				

Memo

Quality Control

W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-			1 Tod Wigi	
******									
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	1
	R	esolution:	Disposition	1:	QA: N/C C	losed:		Date: _	
NCR:		•	WORK ORDI	ER NON-CONFORMAI	NCE (NCF	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	JIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1 3501	on C	Chief Eng	QC Inspector
							-		
								į	
1			1						

NOTE: Date & initial all entries

Page 2

Item ID:

D3574-6

Wednesday, August 18, 2010 11:07:08 AM

Accept

Setup Start

Stop



Revision ID:

**Start Date:** 

Item Name: Cabin Floor Protector

8/18/2010

Start Qty: 2.00

Required Date: 8/20/2010

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date: Date:

Run

Start Stop



Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Deburr if necessary.

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

12

150

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

Memo

0.00

Packaging

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	!							
Part No	<u> </u>	PAR #:	Fault Cate	egory:	_ NCR: Yes !	No DQA:_	Date: _	
	Re	esolution:	Dispositio	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verificati		Approval
	JILI	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section (	C Chief Eng	QC Inspector
		,						

· NOTE: Date & initial all entries

#### Work Order ID 61328

Wednesday, August 18, 2010 11:07:08 AM



Page 3

Item ID:

D3574-6

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Cabin Floor Protector

**Start Date:** 

Required Date: 8/20/2010

8/18/2010

Start Qty: 2.00

Rea'd Otv: 2.00

Date: \_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Operation

Description

Date: \_\_\_\_\_ Tooling:

**SPC (Y/N):** 

Date:

Date:

Start

Run



Stop

Sequence ID/

Work Center ID

160

OC

Memo

QC21- Final Inspection - Work Order Release

0.00

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

W/O:	-		W	ORK ORDER CHANG	ES		<del></del>		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:				
					1				
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C (	losed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section  Action Description  Chief Eng	on B Sign Date	&   Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
•			Office Ling	Office Eng	- Duit				

· NOTE: Date & initial all entries

### **Picklist Print**

Wednesday, August 18, 2010 11:07:08 AM

Work Order ID: 61328

D3574-6 Parent Item:

Parent Item Name: Cabin Floor Protector

**Start Date: 8/18/2010** 

Required Date: 8/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev : A New Issue 07.07.23 EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,885.923	33.6	67.23362	<u> </u>		
										7	10-8-1	12	

GE PLASTICS LEXAN SHEET

<b>Location</b>	Loc Oty	Loc Code	
MAT	2885.9238		·
114032	467.9238		
115261	2418		11820

W/O:			W	ORK ORDER CHANG	ES			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
**************************************									
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	3)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B		cation	Approval	Approval
		Section A	Chief Eng	Action Description  Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector
					; ; ;				

· NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61328
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3,003	X.		N BOJ	
7.37	+/-0.030	7.37	علا		7 B01	
11.00	+/-0.030	11,00	×		4	
15.25	+/-0.030	15.78	*		7	
25.87	+/-0.030	78.26	¥		T	
39.75	+/-0.030	39.75	XŁ.		T	,
44.75	+/-0.030	44.76	8		7	
58.38	+/-0.030	5838	*		Τ .	
63.50	+/-0.030	63,50	8		7	
65.25	+/-0.030	65.28	×		7	
10.25	+/-0.030	86.01	*		۲	
11.87	+/-0.030	(1,87	4		7	
14.75	+/-0.030	14.75	*		7	٠.
26.00	+/-0.030	26.00	×	-	7	
40.87	+/-0.030	40.87			$\tau$	
45.00	+/-0.030	45.00	*		7	
48.00	+/-0.030	48.00	×		7	· · ÷-,
55.13	+/-0.030	55.13	*		+	
61.25	+/-0.030	61.25	Ł		7	
61.88	+/-0.030	61.88	A		T	
64.63	+/-0.030	64.63	*		7	
1.13	+/-0.030	1.13	X		7	
7.63	+/-0.030	7.63	4		τ	
11.00	+/-0.030	(1.00	*		1	
22.10	+/-0.030	33'16	*		7	
22.50	+/-0.030	03.66	×		τ	
24.50	+/-0.030	24.50	*		Ť	
35.13	+/-0.030		*		7	
36.50	+/-0.030	36.50	X		7	
40.00	+/-0.030	40.00	ж		7	
41.88	+/-0.030	41.88	162		T	
43.63	+/-0.030	43.63	X		Ť	
6.75	+/-0.030	6,75	8		7	
9.50	+/-0.030	9.50	×	-	1	

W/O:			WO	RK ORDER CHANG	ES			<i>_</i>	•
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,					·
Part No	:	PAR #:	Fault Cated	lory:	NCR: Yes	No <b>DQ</b>	 A:	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			***************************************
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign	&   Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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					i				1
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6329
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

	X	First Article	Prototype
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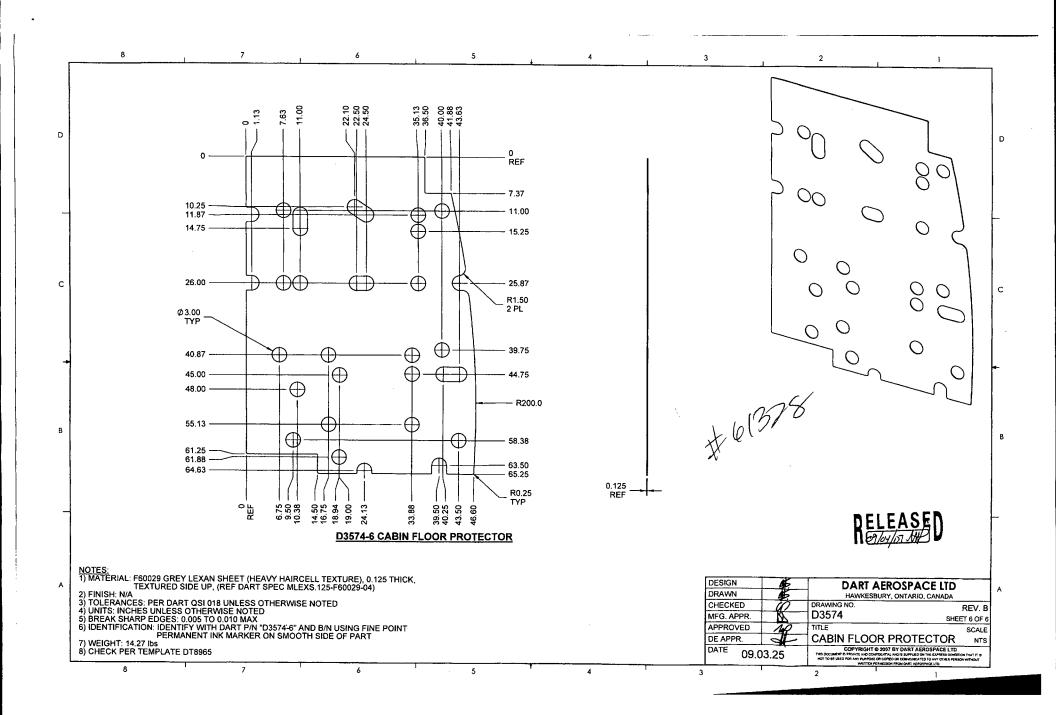
Drawing Tolerance C		Actual Dimension	Accept	Reject	Method of Inspection	Comments		
10.38	+/-0.030	10.38	×		T 1801			
14.50	+/-0.030	14.50	<i>&gt;</i>		7			
16.75	+/-0.030	16.74	7		T	••		
18.94	+/-0.030	18.94	>		7			
19.00	+/-0.030	19.00	8		7			
24.13	+/-0.030	24,13	2		7			
33.88	+/-0.030	33.88	8		7			
39.50	+/-0.030	39.50	×		7			
40.25	+/-0.030	40.50	7		7			
43.50	+/-0.030	43,50	2		T			
46.60	+/-0.030	46.60	Ø		7			
0.125	+/-0.010	130	Ж.		V BOJ			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10 - 8-18	Date: 6/05/19	Date:	N/A

R	ev	Date	Change	Revised by	<b>y</b>	Approved =
	A	08.01.16	New Issue	KJ//DD ,	Λ	
	В	09.05.15	Dimensions updated per Dwg Rev B	KJ 🕈	\$	

W/O:		WORK ORDER CHANGES .										
DATE STEP		PRO	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										Prod Mgr		
							6					
		de formation and the formation										
Part No	:	PAR #:	Fault Category: NCR: Yes No DQA					A:	ı: Date:			
		esolution:										
NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC				ction B		Verifi	cation	Approval	Approval	
DATE		Section A	Initial Chief Eng	Ac1	tion Description Chief Eng		Sign & Date		tion C	Chief Eng	QC Inspector	
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ne was wi												
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NOTE: Date & initial all entries



W/O:			W	ORK ORDER CHANG	GES						
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•									
Part No:		PAR #:	Fault Category: N			NCR: Yes No DQA: Date:					
	R	esolution:	Disposit	QA: N/C Closed:				Date: _	_ Date:		
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR	)				
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			Sign &		cation	Approval	Approval	
		Section A	Chief Eng	Chief Eng		Date	Sect	ion C	Chief Eng	QC Inspector	
				· · · · · · · · · · · · · · · · · · ·							
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NOTE: Date & initial all entries

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